

Date: Friday, 16/05/2008 8:45:50 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LONG PIN BRACKET
Job Number :	39321		
Estimate Number :	11204		
P.O. Number :		Part Number :	D333011
This Issue :	16/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3330 REV D
First Issue :	//	Project Number :	N/A
Previous Run :	35483	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	JLD 08.5.16	Due Date :	06/06/2008
Comment :	Est. A05.01.13 New issue KJ/JLM est b 07.05.14 rev c dwg ec est C 07.12.12 rev D dwg EC verified by:DD		
		Qty:	10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B2500X01000	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty: 0.2734 f(s)/Unit Total: 2.7342 f(s)
 1010-1025 Steel Bar
 Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel(
 M1010-B2.500x01.000)
 Identify for D3330-11
 Batch: M106317

10

08/05/21

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030)

MME 08/05/21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA479 and Dwg D3330
 Identify as D3330-11
 Deburr

J.L 08/05/22 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/05/22 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:50 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG PIN BRACKET

Job Number: 39321

Part Number: D333011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

27 08/05/20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS22*

pl 08-05-22

(110)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/26

Job Completion



MF 08-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39321
Description: Long Pin Bracket		Part Number: D3330-11
Inspection Dwg: D3330	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

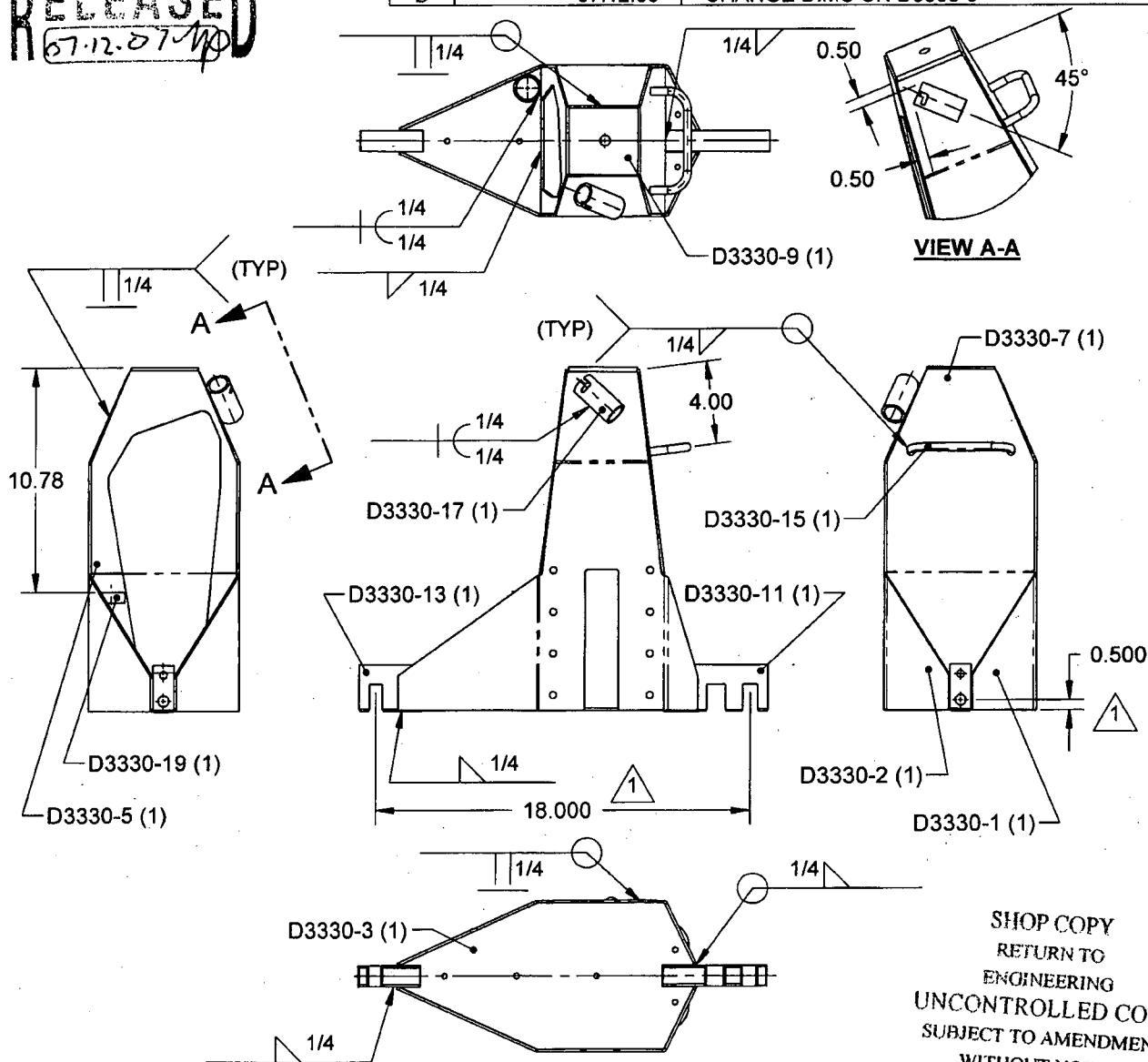
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	5.00	✓			
4.625	+/-0.010	4.635	✓			
0.260	+/-0.010	.262	✓			
Ø.594	+0.005/-0.000	.598	✓			
0.875	+/-0.010	.868	✓			
0.838	+/-0.010	.847	✓			
0.700	+/-0.010	.695	✓			
0.500	+/-0.010	.505	✓			
2.25	+/-0.030	2.250	✓			
0.950	+/-0.010	.950	✓			
Ø.531	+0.005/-0.000	.536	✓			
Ø.348	+0.005/-0.000	.349	✓			
Ø.516	+0.005/-0.000	.519	✓			
0.467	+/-0.010	.463	✓			
1.250	+/-0.010	1.250	✓			
1.00	+/-0.030	.996	✓			
0.10 x 45°	+/-0.5°	.095X45°	✓			

Measured by: JL	Audited by: SS	Prototype Approval:	N/A
Date: 08/05/22	Date: 08/05/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.16	Dwg Rev updated	KJ/EC	
D	07.11.23	0.838 was 0.837	KJ/EC/DD	

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07-12-07

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CHECKED <i>JS</i>	APPROVED <i>MP</i>	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

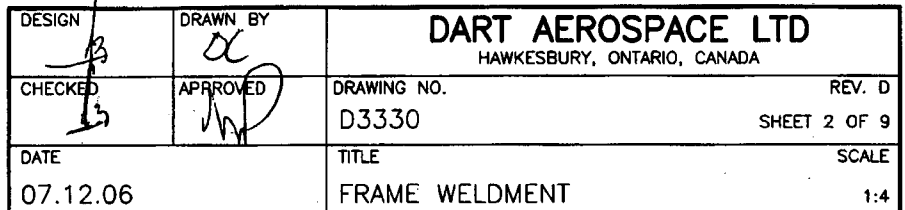
**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

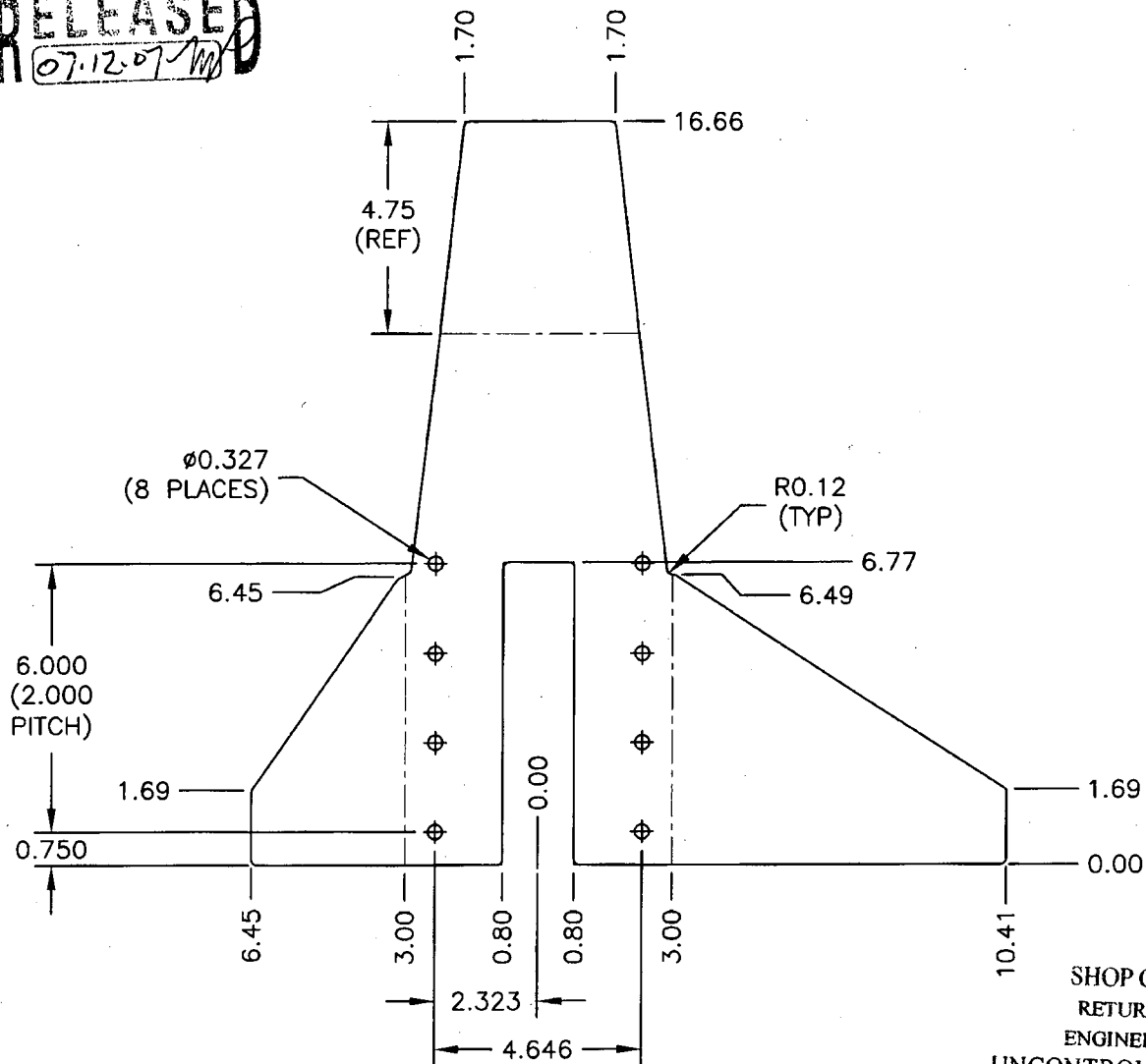
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D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

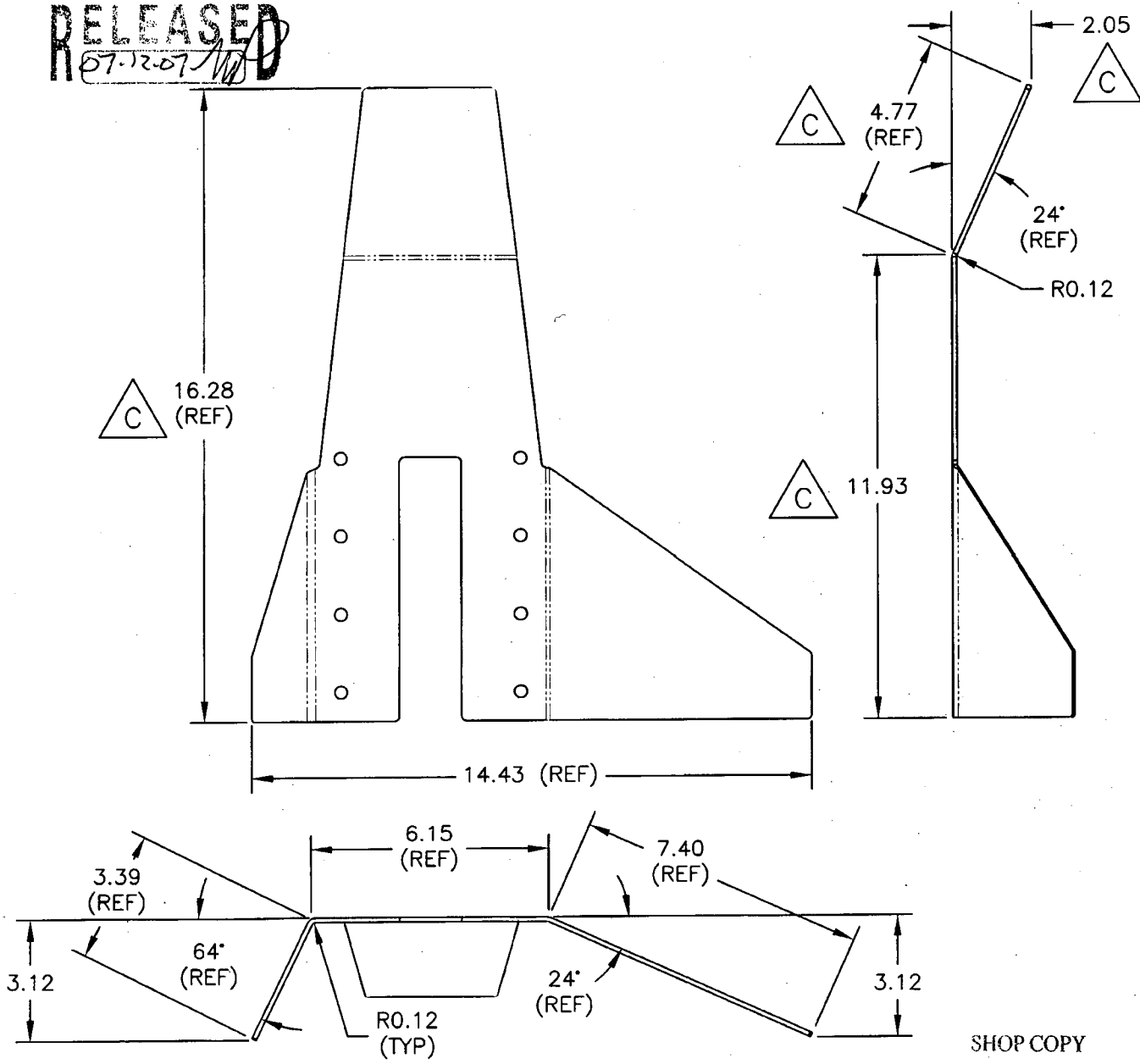
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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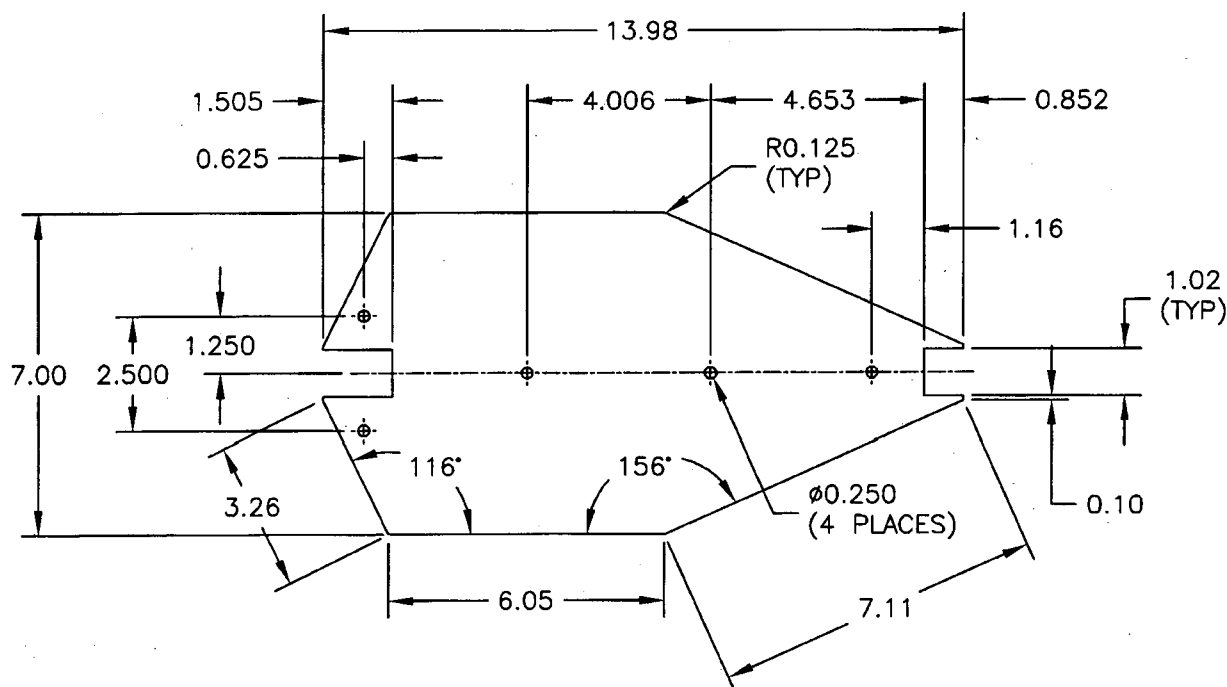
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D3330-3 PLATE

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

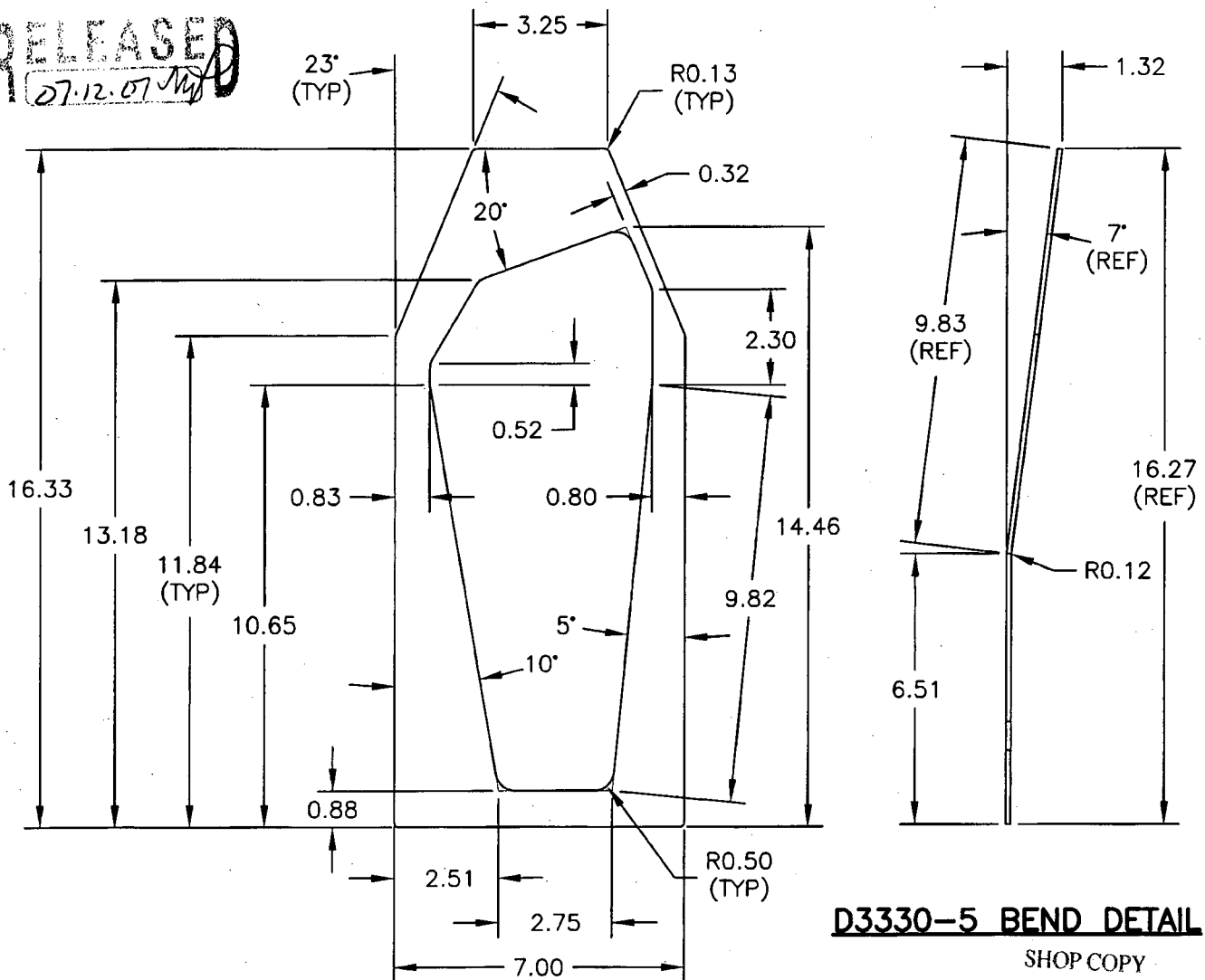
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

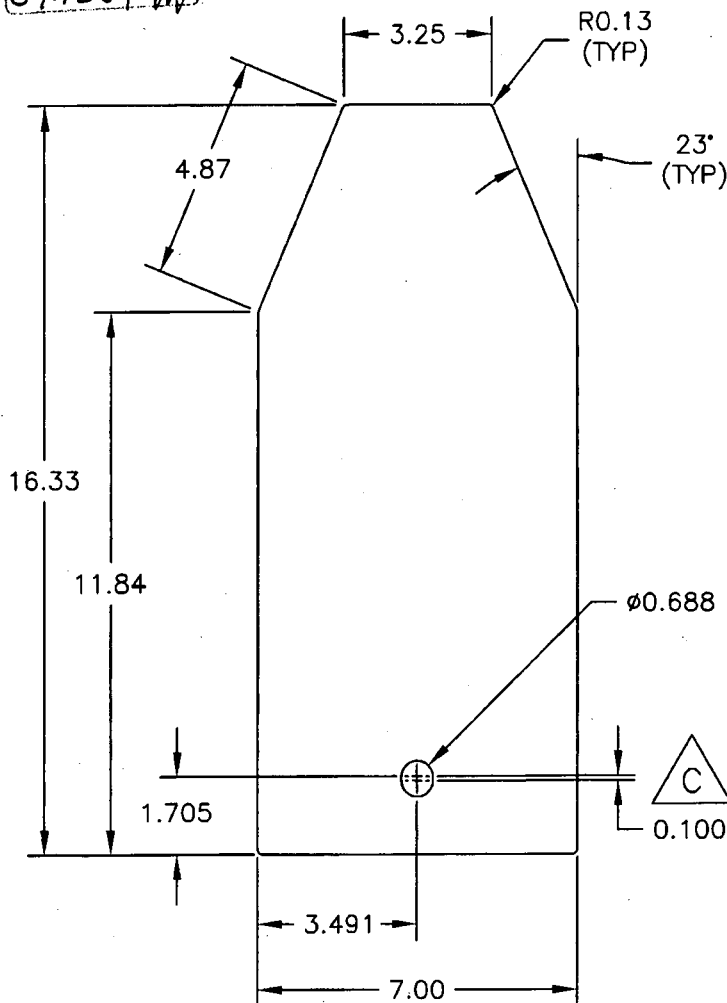
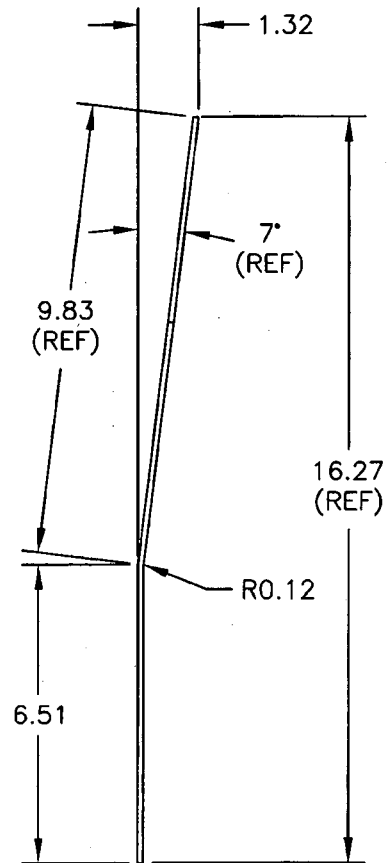
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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

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07.12.07 *[Signature]***FLAT PATTERN****D3330-7 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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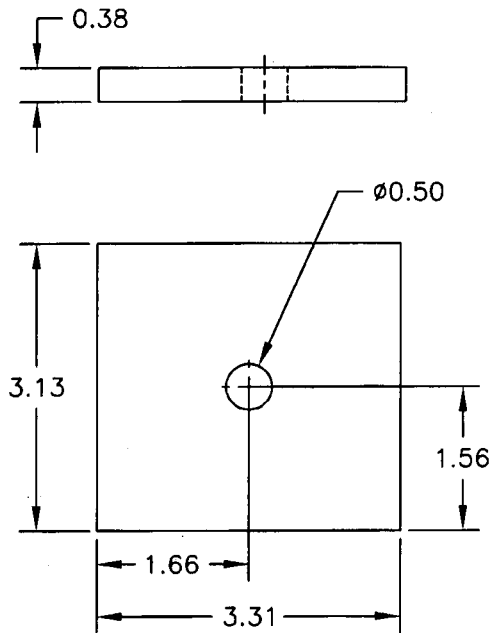
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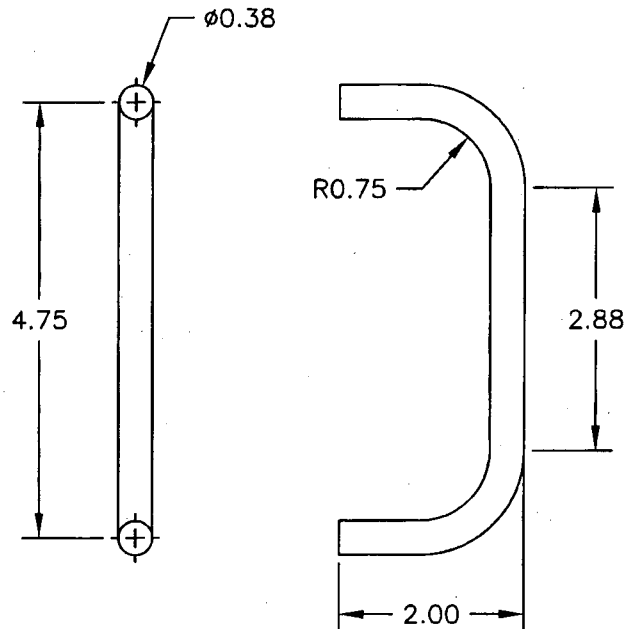
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

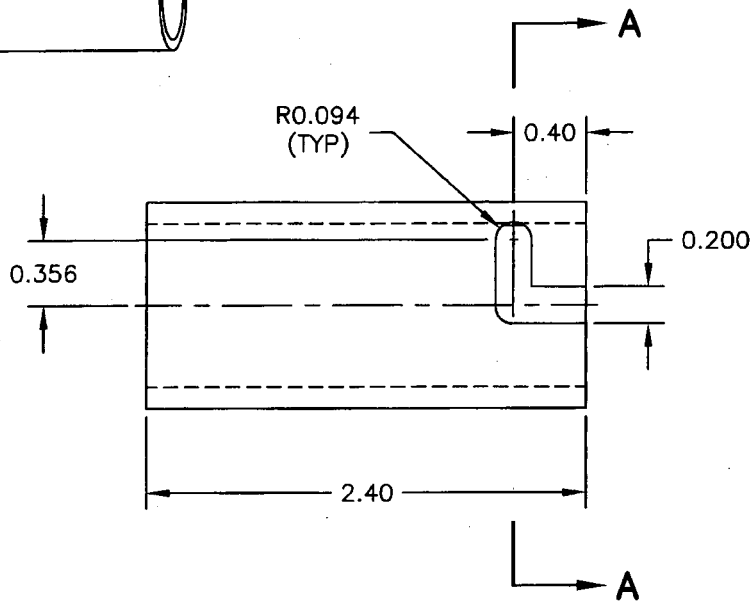
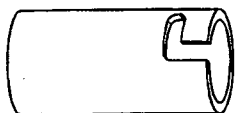
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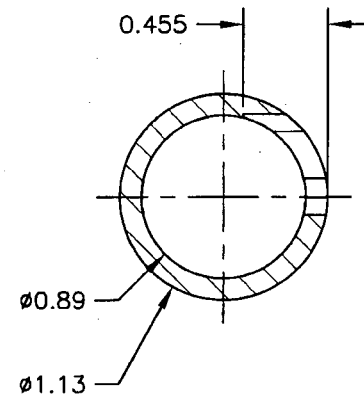
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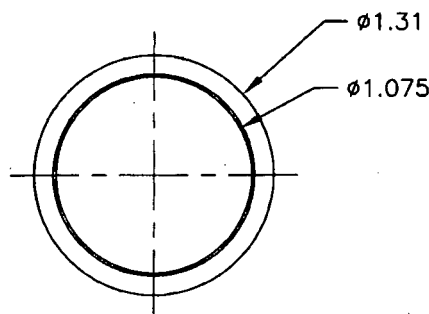
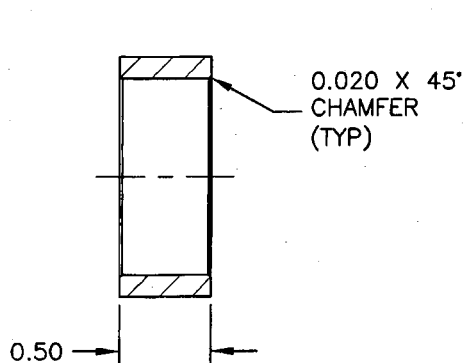


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

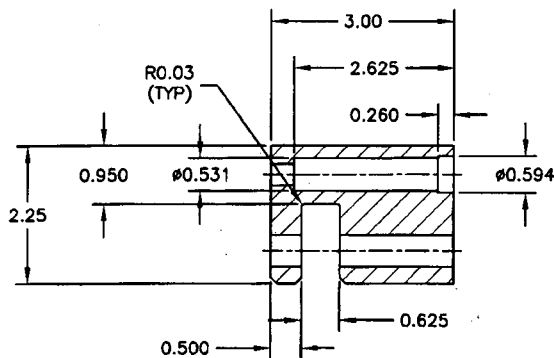
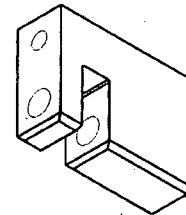
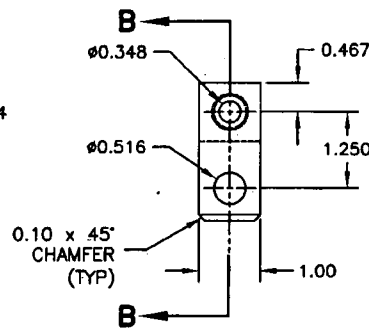
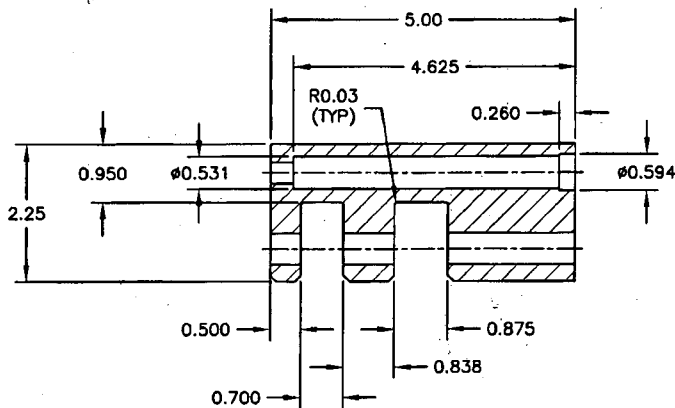
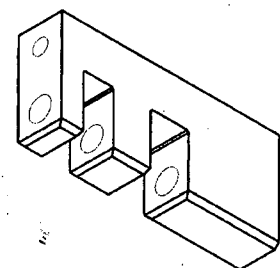
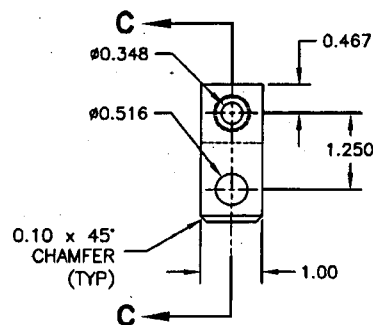
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET****RELEASED**
07.12.07 *[Signature]***SECTION C-C****D3330-11 LONG PIN BRACKET**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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